TECHNICAL SERVICE BULLETIN

BRITISH LEYLAND **AUSTIN MG**

NO. 72 G 2

May, 1972

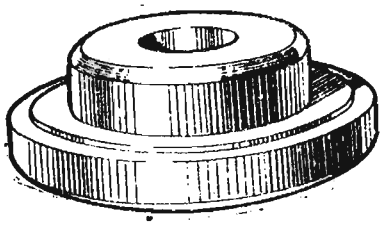
SUBJECT:	MODELS:
Additional Tools Available Austin/MG	All

You have already been advised of the Minimum Special Tools required to service present Austin/MG models. BUT... did you know that there are many additional special tools (readily available from your Distributor) that will save your mechanics' time, and you money, for older models and current models beyond the current minimum requirements.

Check the attached list of tools and see which ones might best fit your needs. There is no substitute for the proper tool as improvisation wastes not only time, but money.

For your convenience the Tool Order and Check List attached can be used as your order form and can be sent directly to your Distributor. Your Service Manual for each model details the use of each special tool listed in this bulletin.

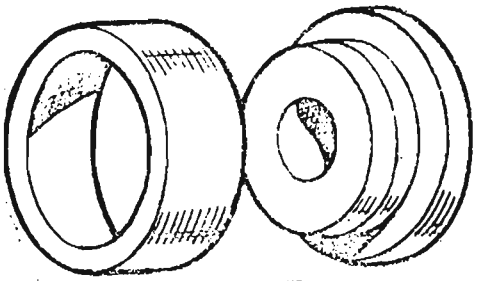
18G 134BC - Crankshaft Primary Gear Oil Seal Replacer Adaptor



18G 134CN - Oil Seal Replacer

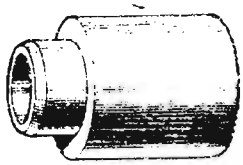
Use with basic tool 18G 134 to replace stator carrier oil seal.

America Automatic



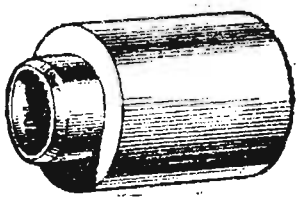
18G 134L - Gearbox Rear Oil Seal Replacer Adaptor

For replacement of gearbox extension oil seals. Use with handle 18G 134



18G 134N - Gearbox Rear Oil Seal Replacer - Adaptor

For the correct and easy replacement of the gearbox extension oil seal. Use in conjunction with 18G 134



18G 144 - Synchromesh Assembly Ring

This tool retains the balls and springs in the synchronizer while it is being pushed into the sleeve or first speed wheel.

18G 182 - Accumulator Housing Remover

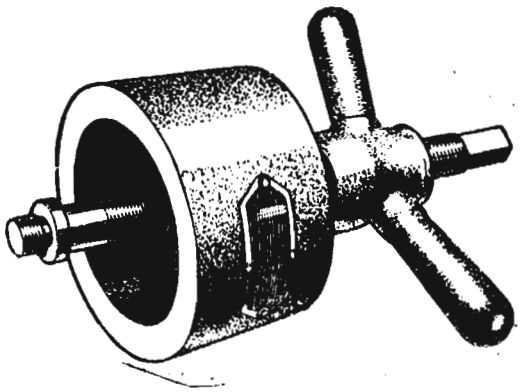
The difficulty of removing the accumulator housing from its bore on the Laycock overdrive unit is completely overcome by the use of this tool.

Austin Healey 100, Healey 100 Six, Healey 3000

PART NO.	AUSTIN AMERICA	MG 1100	SPRITE/ MIDGET	MGB	MGC	HEALEY 3000
18G 134BC	*	*				
18G 134CN	*					
18G 134L			*			
18G 134N				*	*	*
18G 144			*			
18G 182						*

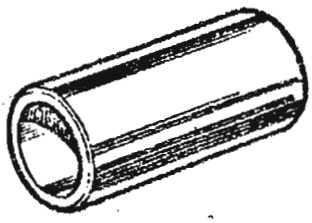
18G 183 - Oil Pump Body Remover

For use on the Laycock overdrive unit. The short screwed end of the extractor bolt is screwed into the oil pump body in place of the special screwed plug. With the squared end of the center screw held firmly with a spanner the oil pump body can be withdrawn by turning the wing nut clockwise.



18G 183A - Adaptor Remover Oil Pump Barrel

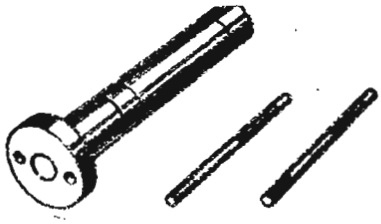
Use with the centre spindle and wing nut from 18G 183 to remove the oil pump from the overdrive unit.



18G 184 - Oil Pump Body Replacer

The guide rods ensure correct lining up and ease replacement of the oil pump body to the Laycock overdrive unit.

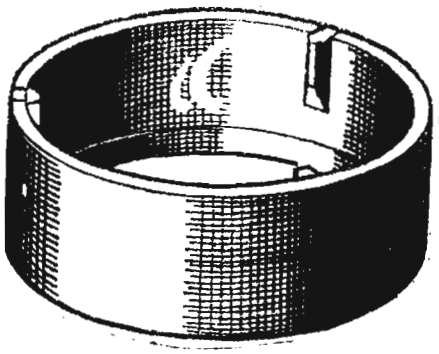
(18G 184/01 Pin Set) Only



18G 222 - Synchromesh Unit Assembly Ring - Second Speed

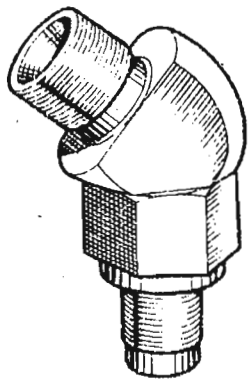
Designed to facilitate the assembly of mated synchronizer and sleeve by enabling the springs and balls to be inserted quickly and easily.

18G 223 - Synchromesh Unit Assembly Ring - Third and Top



18G 251D - Pressure Test Adaptor

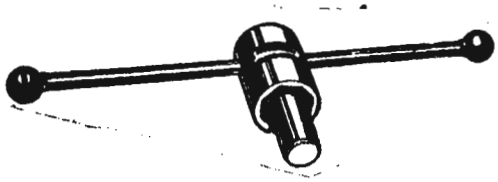
Used in place of the operating valve plug to connect a pressure gauge for the oil pressure test.



PART NO.	AUSTIN AMERICA	MG 1100	SPRITE/ MIDGET	MGB	MGC	HEALEY 3000
18G 183				*		*
18G 183A				*		
18G 184 18G 184/01						*
18G 222 18G 223				*		
18G 251D				*		

18G 258 - Rear Hub Nut Spanner

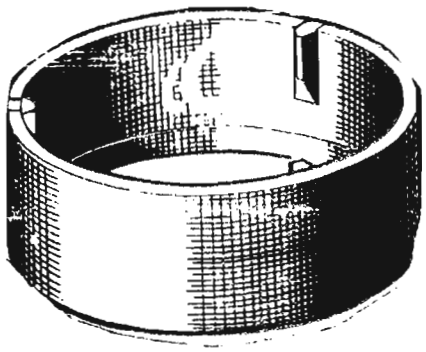
The long pilot locates in the axle tube to ensure an even pull on the thin octagonal hub nut.



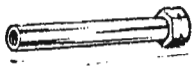
18G 262 - Synchromesh Unit Assembly Ring (First and Second Speed)

18G 263 - Synchromesh Unit Assembly Ring (Third and Top Speed)

Designed to facilitate the assembly of mated synchronizer and sleeve by enabling the springs and balls to be inserted quickly and easily.



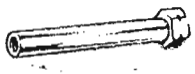
18G 304A - Bolt Adaptor - 1/2 in. UNF



18G 304B - Bolt Adaptor - 7/16 in. UNF

18G 304F - Bolt Adaptor

For use with basic tool 18G 304



18G 304H - Hub Remover Thrust Pad

For use with basic tool 18G 304

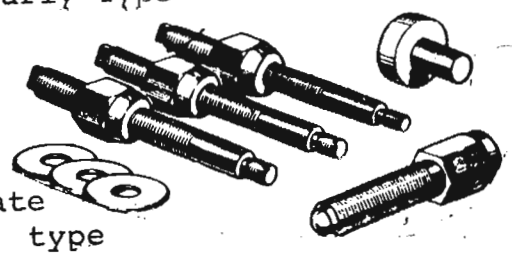
18G 304J - Hub Remover Thrust Pad

18G 304K - Hub Remover Thrust Pad

18G 304M - Flywheel and Clutch Remover Adaptor -Early Type

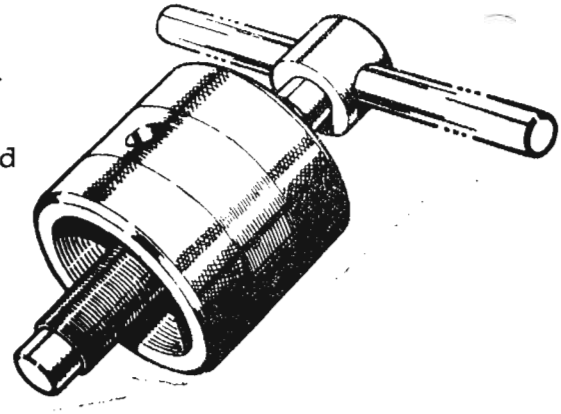
18G 304M/1 Thrust Pad Also Fits 18G 304N
18G 304M/4 Center Screw Also Fits 18G 304N
18G 304M/5 Stud Set Includes Nuts and Washers

18G 304N - Flywheel and Clutch Remover Adaptor- Late type
18G 304N/1 Stud Set Includes Nuts and Washers



PART NO.	AUSTIN AMERICA	MG 1100	SPRITE/ MIDGET	MGB	MGC	HEALEY 3000
18G 258						*
18G 262 18G 263						* *
18G 304A					*	
18G 304B				*	*	*
18G 304F			*			
18G 304H			*			
18G 304J				*	*	
18G 304K						*
18G 304M 18G 304M/1 18G 304M/4 18G 304M/5		*				
18G 304N 18G 304N/1	*	*				

18G 363 - Hub Remover - Wire Wheels Early Models



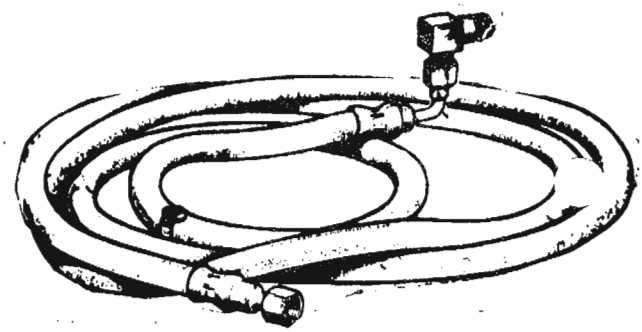
Designed to withdraw left-hand and right-hand 'knock-on' hubs. The body is internally threaded with a left-hand thread in one end and a right-hand thread in the other.

12 T.P.I.

18G 502A - Pressure Gauge

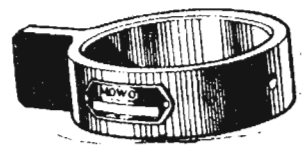
Automatic

18G 502K - Pressure Hose



Automatic

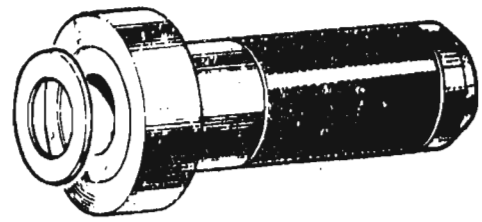
18G 572 - Synchromesh Unit Assembly Ring



Designed to facilitate the assembly of mated synchronizer and sleeve by enabling the springs and balls to be inserted quickly and easily.

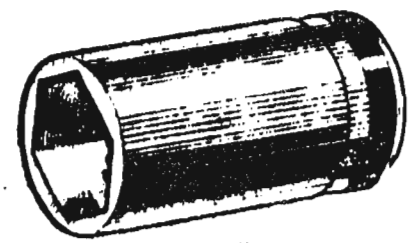
NOTE: For use in current synchronizers, machine 0.005" from the 2.476/2.484' inside diameter.

18G 579 - First and Third Motion Shaft Bearing Replacer



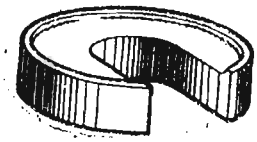
HAC 63 - Washer

18G 587 - Socket



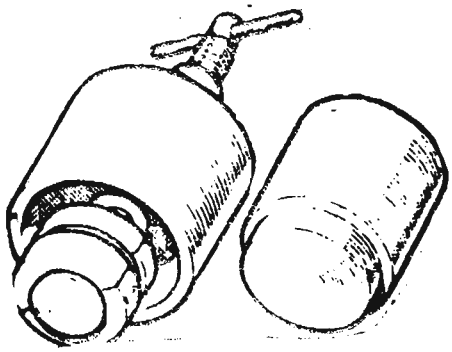
PART NO.	AUSTIN AMERICA	MG 1100	SPRITE/ MIDGET	MGB	MGC	HEALEY 3000
18G 363			*	*		*
18G 502A	*				*	
18G 502K	*				*	
18G 572	*	*				
18G 579 HAC 63	*	*				
18G 587	*	*				

18G 613 - Third Motion Shaft Bearing Remover



For use when removing the third motion shaft bearing to prevent damage to the housing bore.

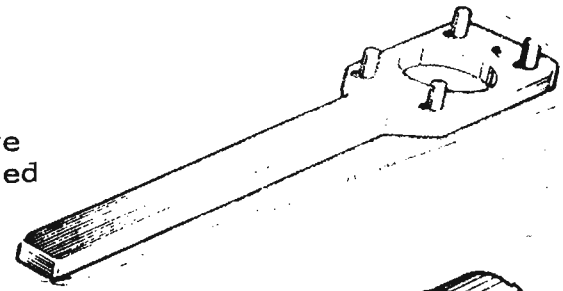
18G 617A - Roller Bearing Outer Rear Remover and Replacer



To remove bearing race of 1st motion shaft in flywheel housing. Instructions for use will be packed with tool and also printed in Workshop Manuals, (replacing 18G 617 which is now discontinued).

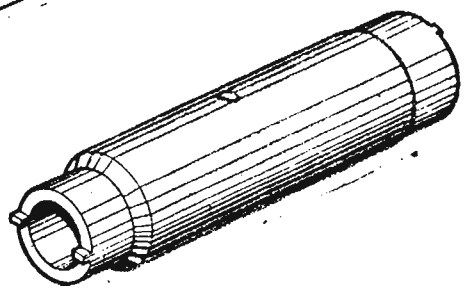
(18G 617A/2 Plug Only)

18G 669 - Drive Shaft Coupling Flange Wrench



For use when removing or replacing the flange retaining nuts, thus preventing possible damage to the transmission casing when using improvised methods.

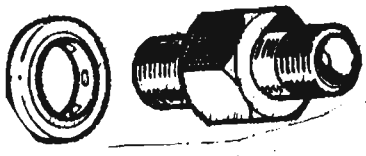
18G 671 -Switch Bezel Spanner



Used to enable the bezel nuts on ignition and lighting switches to be removed and replaced without damage to the fascia panel.

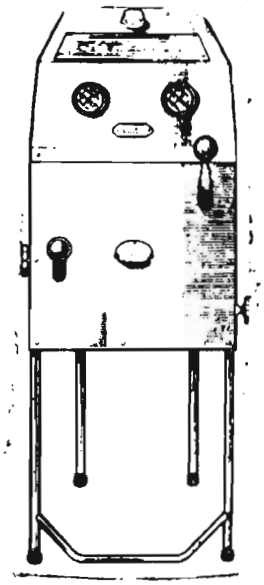
18G 677C - Adaptor

America Automatic



PART NO.	AUSTIN AMERICA	MG 1100	SPRITE/ MIDGET	MGB	MGC	HEALEY 3000
18G 613	*	*				
18G 617/A 18G 617/A2	*	*				
18G 669	*	*				
18G 671		*	*	*		*
18G 677/C	*					

18G 703 - The Hydrolastic Suspension Service Unit

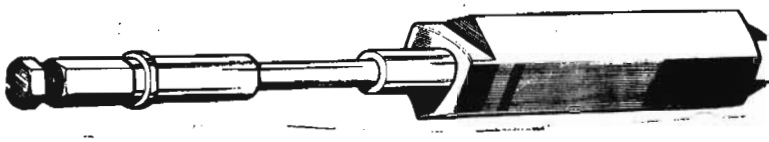


Service Parts Available for 18G 703

18G 703/A - Major Overhaul Seals and Gaskets
18G 703/B - Minor Overhaul Seals and Gaskets
18G 703/16 - Top Pressure Pump Valve
18G 703/25 - Bleed Valve Tap
18G 703/27 - Bleed Valve Body
18G 703/34 - Nylon Tube 6' 6"
18G 703/68 - Fluid Tank
18G 703/85 - No Loss Connector
18G 703/86 - Renrut Connector

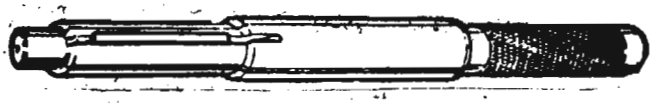
18G - 1002 Gudgeon Pin Remover/Replacer

'A' Series Engine Only



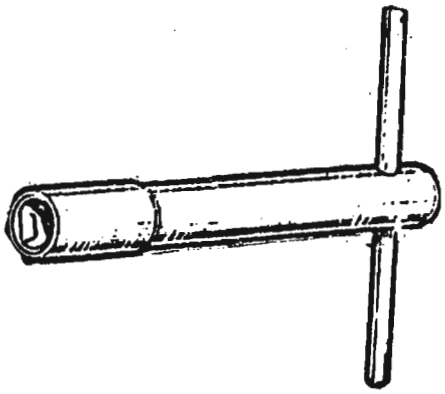
18G 1039 - Dummy Mainshaft

To line-up splines of planet carrier and the uni-directional clutch, before fitting to gearbox assembly (Workshop Manual, Section Fa. 10 refers.)



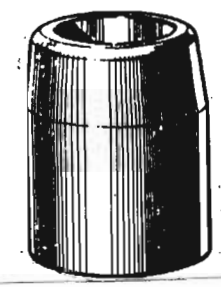
18G 1040 - Oil Pump Body Key

To remove the plug from the over-drive oil pump body.



18G 1043 - Crankshaft Primary Gear Oil Seal Protector Sleeve

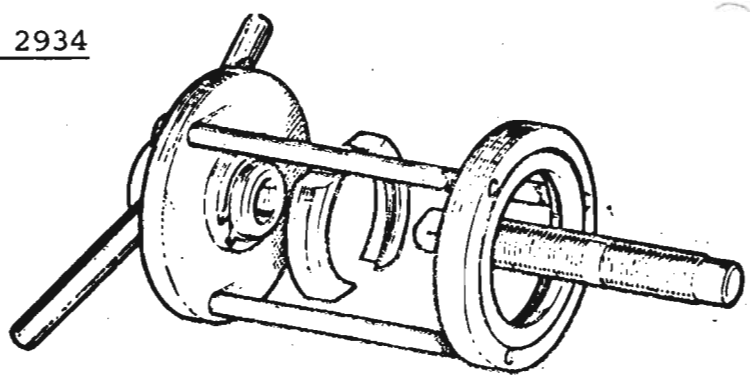
For use when fitting the flywheel housing to prevent the clutch splines on the crankshaft primary gear damaging the oil seal. The two pilot studs must be screwed into the two bottom tapped holes in the cylinder block.



PART NO.	AUSTIN AMERICA	MG 1100	SPRITE/ MIDGET	MGB	MGC	HEALEY 3000
18G 703 18G 703/A 18G 703/B 18G 703/16 18G 703/25 18G 703/27 18G 703/34 18G 703/68 18G 703/85 18G 703/86	*	*				
18G 1002	*		*			
18G 1039			*			
18G 1040			*			
18G 1043	*	*				

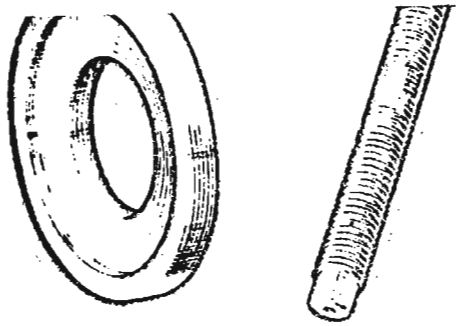
18G 1068 - Remover/Replacer Primary Driver Gear Oil Seal, 13H 2934

18G 1068/04 - Center Screw
18G 1068/06 - Jaw Set



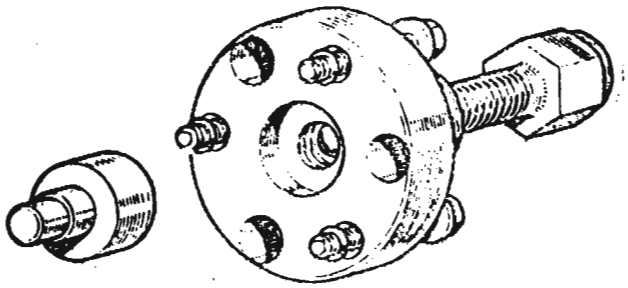
18G 1068A - Bolt Adaptor

America Automatic



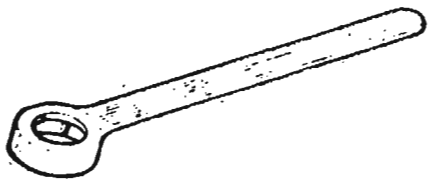
18G 1086 - Converter Remover

America Automatic
(HAC 66 Set = Three (3) Step Washers and Six (6) Bolts)



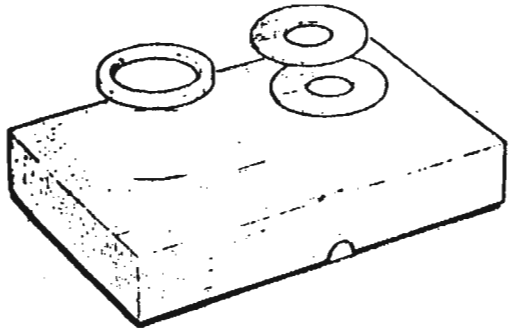
18G 1088 - Primary Gear Wrench

America Automatic



18G 1089 - Idler & Input Gauge Set

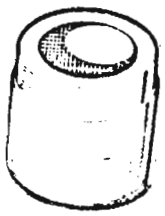
America Automatic
(HAC 62 Wax Only)



PART NO.	AUSTIN AMERICA	MG 1100	SPRITE/ MIDGET	MGB	MGC	HEALEY 3000
18G 1068 Complete 18G 1068/04 18G 1068/06	*	*				
18G 1068A	*					
18G 1086 HAC 66	*					
18G 1088	*					
18G 1089 HAC 62	* *					

18G 1089A - Gauge Set Adaptor

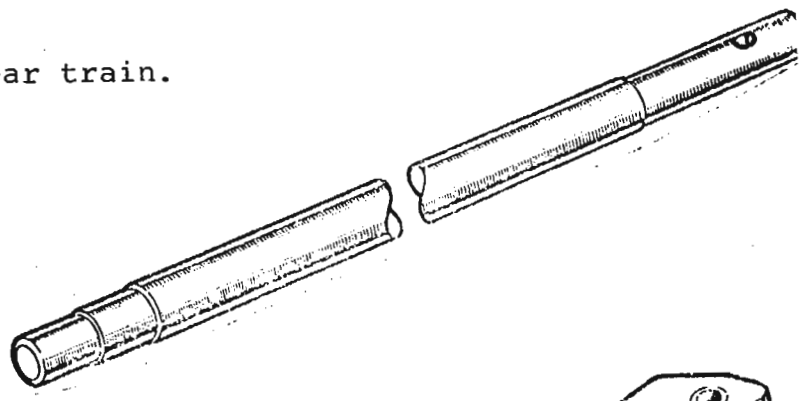
America Automatic



18G 1093 - Dummy Shaft

Forward gear carrier assembly - To assemble and check clearances in gear train.

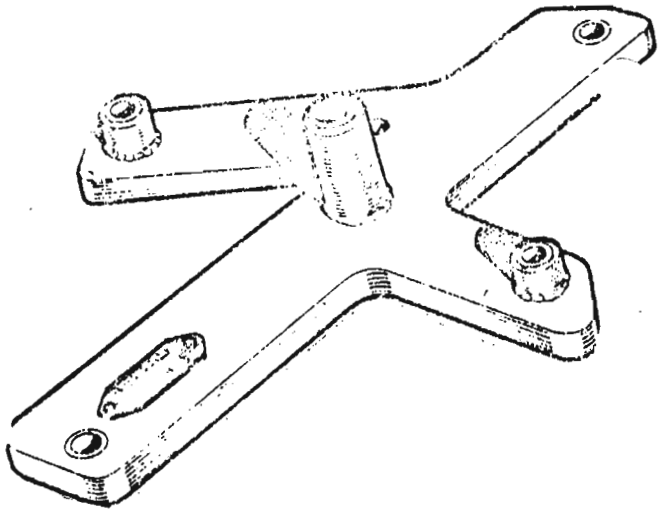
America Automatic



18G 1094 - Oil Pump Pipes Chest Alignment Tool

America Automatic

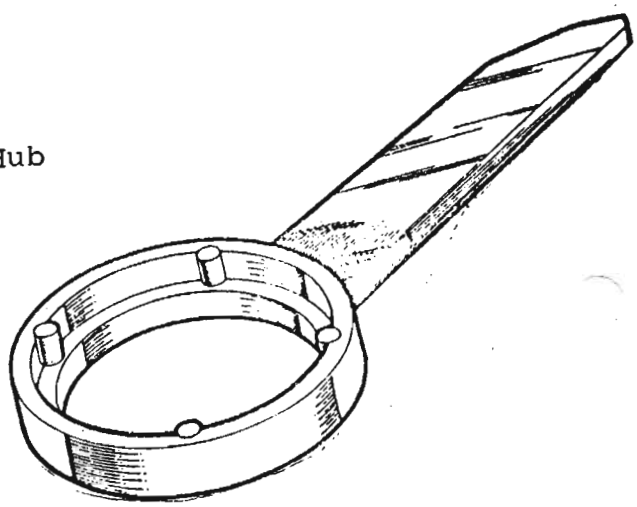
To position oil pump pipes before assembling transmission front cover.



18G 1095 - Holder - Top and Reverse Clutch Hub

To hold reverse clutch hub when tightening forward.

America Automatic

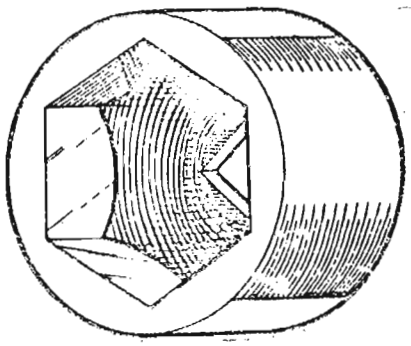


PART NO.	AUSTIN AMERICA	MG 1100	SPRITE/ MIDGET	MGB	MGC	HEALEY 3000
18G 1089A	*					
18G 1093	*					
18G 1094	*					
18G 1095	*					

18G 1096 - Socket Spanner

To tighten forward clutch hub nut.

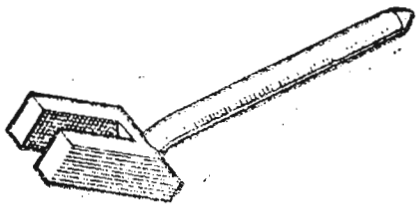
America Automatic



18G 1097 - Retainer Forward Clutch

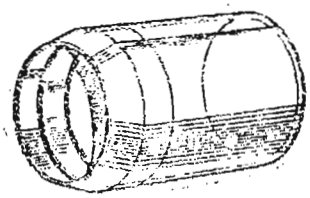
To retain forward clutch when removing transmisson front cover.

America Automatic



18G 1098 - Protector Sleeve

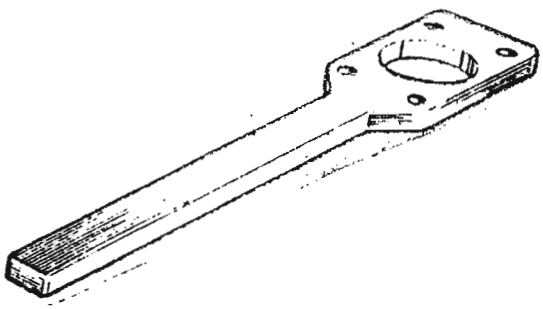
America Automatic



18G 1100 - Driveshaft Coupling Wrench

To hold drive flange when tightening or removing retaining bolts.

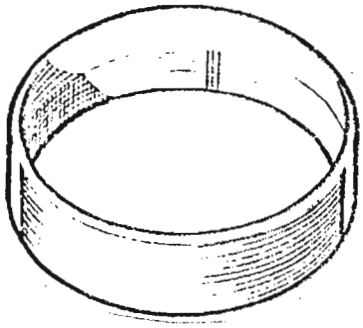
America Automatic.



18G 1102 - Replacer Forward Clutch Piston Seal

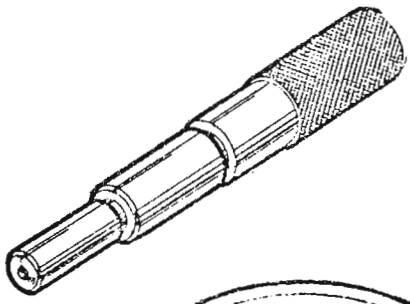
To dismantle and re-assemble forward clutch unit.

America Automatic.



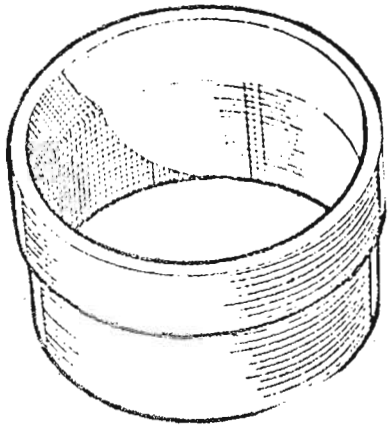
PART NO.	AUSTIN AMERICA	MG 1100	SPRITE/ MIDGET	MGB	MGC	HEALEY 3000
18G 1096	*					
18G 1097	*					
18G 1098	*					
18G 1100	*					
18G 1102	*					

18G 1106 - Centralizer Governor Housing To Front Cover



To centralize governor housing assembly to transmission front cover. This tool must be used when assembling auxilary pump and/or governor to front cover.

18G 1120 - Replacer Reverse Clutch Piston Seal

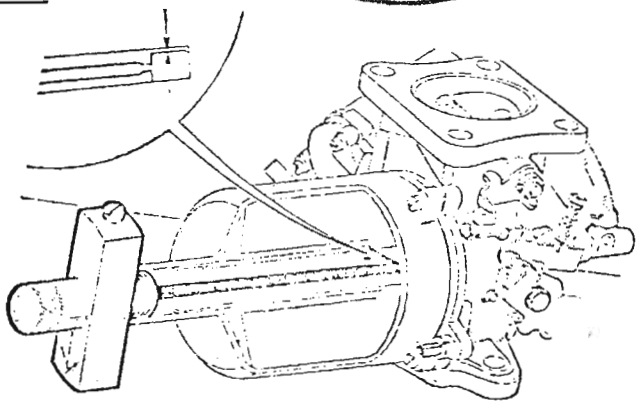


To dismantle and re-assemble reverse clutch unit.

America Automatic

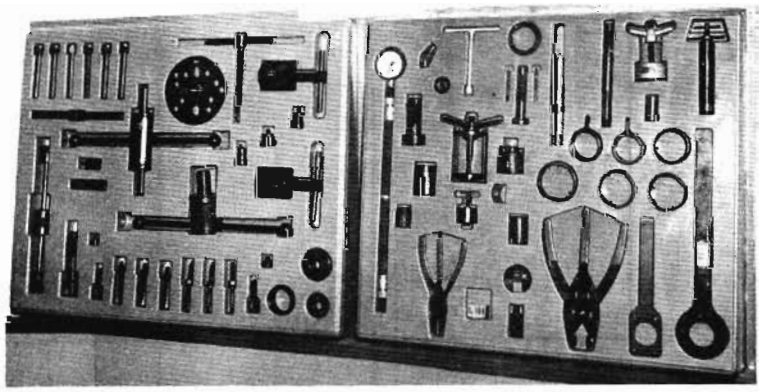
HAC 61 - S.U. Carburetter Piston Loading Tool

(HAC 61A Tip Set)



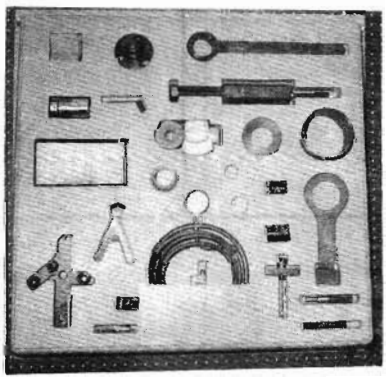
DID 13 - Tool Board

- A Tool for Tools -
PROTECT YOUR INVESTMENT!
Section 1 and 2.



DID 13/3 - Section 3

Board only, not including tool.

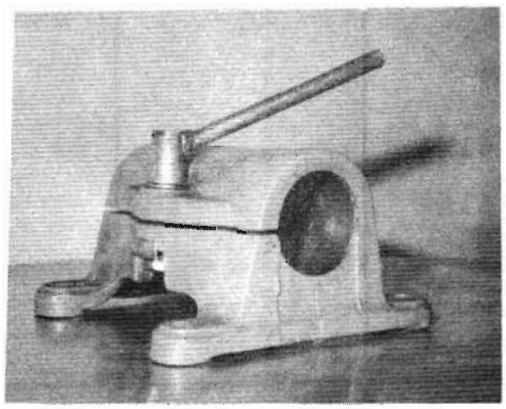


PART NO.	AUSTIN AMERICA	MG 1100	SPRITE/ MIDGET	MGB	MGC	HEALEY 3000
18G 1106	*					
18G 1120	*					
HAC 61 HAC 61A		*	*	*	*	*
DID 13 Section 1 and 2 DID 13/3 Section 3	*	*	*	*	*	*

All 'A' and 'B' type engines can be assembled complete, less filter and Alternator and rotated to any 45° position while fixed to the Stand.

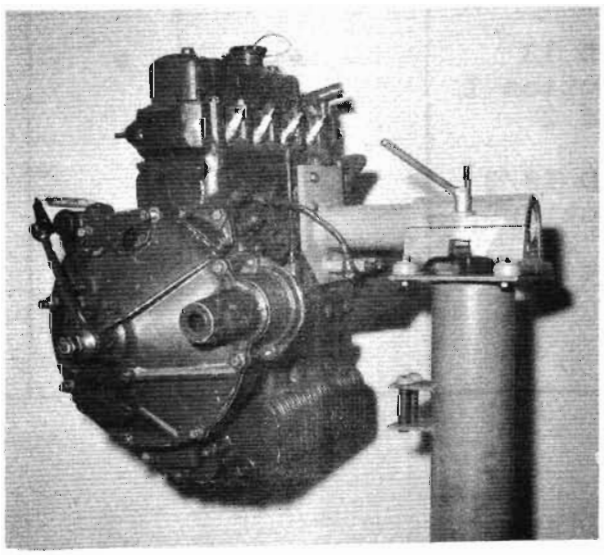
HAC 800 - Stand

HAC 801 - Fixture



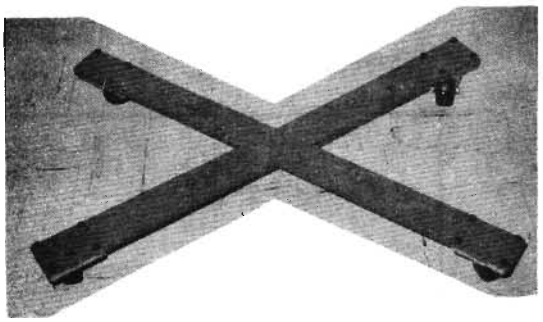
HAC 802 - Adaptor 'A'

'A' Series Only



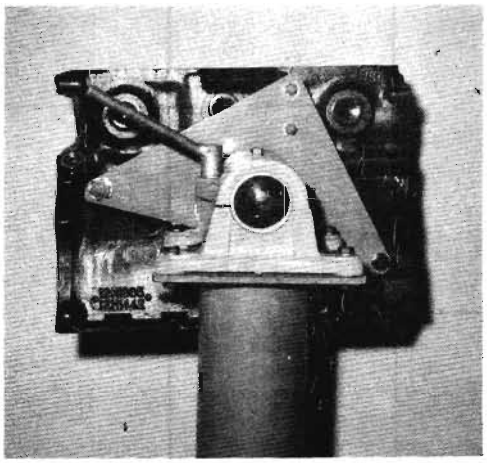
PART NO.	AUSTIN AMERICA	MG 1100	SPRITE/ MIDGET	MGB	MGC	HEALEY 3000
HAC 800	*	*	*	*		
HAC 801	*	*	*	*		
HAC 802	*	*	*			

HAC 803 - Wheel Base

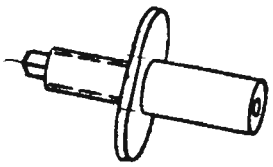


HAC 804 - Adaptor 'B'

'B' Series



HAC 68 - Wire Wheel Hub Grease Cap Remover



PART NO.	AUSTIN AMERICA	MG 1100	SPRITE/ MIDGET	MGB	MGC	HEALEY 3000
HAC 803	*	*	*	*		
HAC 804				*		
HAC 68			*	*		

BRITISH LEYLAND

ADDITIONAL TOOLS AVAILABLE AUSTIN/MG

Dealer _____ Distributor _____

_____ Code No. _____

_____

This is an order for the tools as indicated.

Date _____ Dealer's Signature _____

TOOL ORDER AND CHECK LIST

Tool No.	Description	On Hand	To Order
18G 134BC	Crankshaft Primary Gear Oil Seal Replacer		
18G 134CN	Oil Seal Replacer		
18G 134L	Gearbox Rear Oil Seal Replacer/Adaptor		
18G 134N	Gearbox Rear Oil Seal Replacer/Adaptor		
18G 144	Synchromesh Assembly Ring		
18G 182	Accumulator Housing Remover		
18G 183	Oil Pump Body Remover		
18G 183A	Adaptor Remover Oil Pump Barrel		
18G 184	Oil Pump Body Replacer		
18G 222	Synchromesh Unit Assembly Ring 2nd Speed		
18G 223	Synchromesh Unit Assembly Ring 3rd Speed		
18G 251D	Pressure Test Adaptor		
18G 258	Rear Hub Nut Spanner		
18G 262	Synchromesh Unit Assembly Ring 1 & 2		
18G 263	Synchromesh Unit Assembly Ring 3		
18G 304A	Bolt Adaptor 1/2 inch UNF		
18G 304B	Bolt Adaptor 7/16 inch UNF		
18G 304F	Bolt Adaptor		
18G 304H	Hub Remover Thrust Pad		
18G 304J	Hub Remover Thrust Pad		
18G 304K	Hub Remover Thrust Pad		
18G 304M	Flywheel & Clutch Remover Adaptor - Early		
18G 304N	Flywheel & Clutch Remover Adaptor - Late		
18G 363	Hub Remover - Wire Wheels - Early		
18G 502A	Pressure Gauge		
18G 502K	Pressure Hose		
18G 572	Synchromesh Unit Assembly Ring		
18G 579	1st and 3rd Motion Shaft Bearing Replacer		
18G 587	Socket		
18G 613	3rd Motion Shaft Bearing Remover		
18G 617A	Roller Bearing Outer Rear Remover/Replacer		
18G 669	Drive Shaft Coupling Flange Wrench		

Tool No.	Description	To Hand	To Order
18G 671	Switch Bezel Spanner		
18G 677/C	Adaptor		
18G 703	Hydrolastic Suspension Service Unit		
18G 1002	Gudgeon Pin Remover/Replacer		
18G 1039	Dummy Mainshaft		
18G 1040	Oil Pump Body Key		
18G 1043	Crankshaft Primary Gear Oil Seal		
18G 1068	Remover/Replacer Primary Gear Oil Seal		
18G 1068A	Bolt Adaptor		
18G 1086	Converter Remover		
18G 1088	Primary Gear Wrench		
18G 1089	Idler and Input Gauge Set		
18G 1089A	Gauge Set Adaptor		
18G 1093	Dummy Shaft		
18G 1094	Oil Pump Pipes Chest Alignment Tool		
18G 1095	Holder - Top and Reverse Clutch		
18G 1096	Socket Spanner		
18G 1097	Retainer Forward Clutch		
18G 1098	Protector Sleeve		
18G 1100	Drive Shaft Coupling Wrench		
18G 1102	Replacer Forward Clutch Piston Seal		
18G 1106	Centralizer Governor Housing		
18G 1120	Replacer Reverse Clutch Piston Seal		
HAC 61	S.U. Carburetor Piston Loading Tool		
DID 13, 1 & 2	Tool Board		
DID 13/3, 3	Tool Board		
HAC 800	Stand		
HAC 801	Fixture		
HAC 802	Adaptor 'A'		
HAC 803	Wheel Base		
HAC 804	Adaptor 'B'		
HAC 68	Front Hub Grease Cup Remover		